

# Work Order ID 51272

August 13, 2009 10:54:39 AM

Page 1

Item ID: D205-634-041

Accept

Revision ID: D

Item Name: Replacement Skidtube

Start Date: 8/13/09 Start Qty: 1.00

Required Date: 10/13/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *CL MF* Date: *09/08/13* Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

*N/A*

110

0.00



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

*D*

*u 9/8/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

1 0 BE 08/08/09

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> Sorklosky



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140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 09/08/19

BE 09/08/19

A.W.M  
BE 09/08/20

W/O:		WORK ORDER CHANGES					
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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

⇒ 809/08/28

ⓧ

/

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 809/08/28

ⓧ

/

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

⇒ 809/08/31

1

/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M112260

2:15pm

320°F

2:45pm

0.00

41 09/08/31

1

0

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

09-09-01

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

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200

0.00



HandFinish

Memo

0.00

Hand Finishing

- 1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates  
A/R ☐ ☐ ☐ Sikaflex-291 *M 112 391*  
Sikaflex expire date: *10/20*
- 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580
- 3-Inspect for foreign object per QSI 024
- 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive  
A/R ☐ ☐ ☐ Sikaflex-291 *M 112 391*  
Sikaflex expire date: *10/20*
- 5-Wing Walk as per Dwg D2580 and QSI 005 4.4  
Batch: *M 112 106*

*br 09-09-02.*

W/O:		WORK ORDER CHANGES					
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Page 7

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Required Date: 10/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

⇒ 50210102



Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

PPP 51490

9/9/28 @ 84

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/09/30 98

Quality Control

CL 09/09/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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August 13, 2009 10:54:39 AM

Page 1

Work Order ID: 51272

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2580-1RevD

Manufactured

No

110

Each

8.0000

1.0000



205 Skidtube bent detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

6

50757

6

Main Warehouse

ST

2

50758

2

D2576-3RevG

Manufactured

No

140

Each

147.0000

1.0000



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

147

43504

46

46661

101

D

M 9/8/17

B 50761

1 8E 09/08/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	92.0000	20.0000			

Crossbolt Spacer

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

92

43988

4

46434

4

46956

2

47797

28

48272

54

*\* 351314 x9*

*BE 09/08/19*

D2855RevA

Manufactured

No

200

Each

37.0000

1.0000



Cap

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP6

37

50513 ✓

37

*I BK 0909-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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AN3-5A 		Purchased	No			200	Each	2,540.000	2.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2540	
100188 ✓	226	
105057	2246	
15205	68	

2 BL 09-09-2

AN960JD10L 		Purchased	No			200	Each	6,733.000	2.0000			
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6733	
101291	16	
104885	153	
105793	236	
109632 ✓	1328	
110985	5000	

2 BL 09-09-2

W/O:		WORK ORDER CHANGES					
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ALS7-1032-130		Purchased	No			200	Each	3,628.000	50.0000			



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3628
105855	16
108606	52
111529	1560
111779 ✓	2000

AN3C4A

Purchased

No

200

Each

1,222.000

50.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1222
112082	40
112314 ✓	1182

50 Bk 09-09-2

50 Bk 09-09-2

August 13, 2009 10:54:39 AM

Shop Packet Print

Page 4

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AN960C10L Purchased No 200 Each 3,764.000 50.0000



washer

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 100

103585 100

Main Warehouse

ST 3664

112116 ✓ 3664

D3566-13RevC

Manufactured

No

200

Each

29.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 29

45717 1

46889 2

48166 10

50265 ✓ 16

50 Bl 09-09-2.

1 Bl 09-09-2.

August 13, 2009 10:54:39 AM

Shop Packet Print

Page 5

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D3566-5RevC		Manufactured	No			200	Each	4.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse 51260

ST 4

36113 1

46186 1

47318 1

48167 1

D3566-1RevC

Manufactured No

200

Each

13.0000

2.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse 51259

ST 13

46349 1

47434 2

48557 3

51218 7

1 Bl 09-09-2

2 Bl 09-09-2

August 13, 2009 10:54:39 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 13, 2009 10:54:39 AM

Page 7

Work Order ID: 51272

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-11RevD

Manufactured

No

200

Each

15.0000

1.0000



Wearshoe

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

51256

1

BK 09-09-2

ST

15

45823

1

48553

4

50112

10

D3564-13RevD

Manufactured

No

200

Each

39.0000

1.0000



Wearshoe

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FP17

24

48554

2

50270 ✓

22

Main Warehouse

ST

15

45409

3

46495

10

47867

2

1

BK 09-09-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 13, 2009 10:54:39 AM

Work Order ID: 51272



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube


Start Date: 8/13/09

Required Date: 10/13/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD  Wearshoe		Manufactured	No			200	Each	3.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

51258

1 Bl 09-09-2

ST

3

44659

1

45825

1

48556

1

D3564-5RevD

Manufactured No

200

Each

6.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

OFFSHORE

51257

1 Bl 09-09-2

FG

2

34806

2

Main Warehouse

FP19

2

48555

2

Main Warehouse

ST

2

45824

1

47433

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 13, 2009 10:54:39 AM

Work Order ID: 51272



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 8/13/09

Required Date: 10/13/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC		Manufactured	No			200	Each	670.0000	16.0000			

O-Ring, 205 Skidtube

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

670

27168

44

29908

626

D2594-1RevC

Manufactured

No

200

Each

476.0000

16.0000



Plug, 205 Skidtube

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

476

42221

16

42807

92

43884

3

46435

2

47251 ✓

363

16 BR 09-09-2

16 BR 09-09-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN #	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

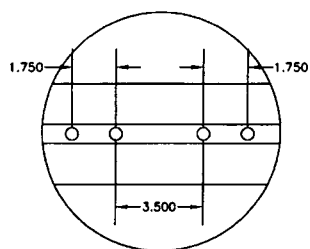
SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 51272**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

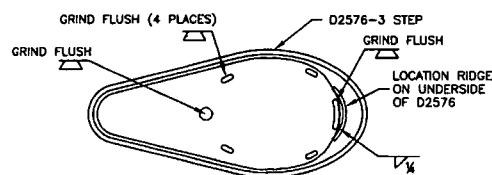
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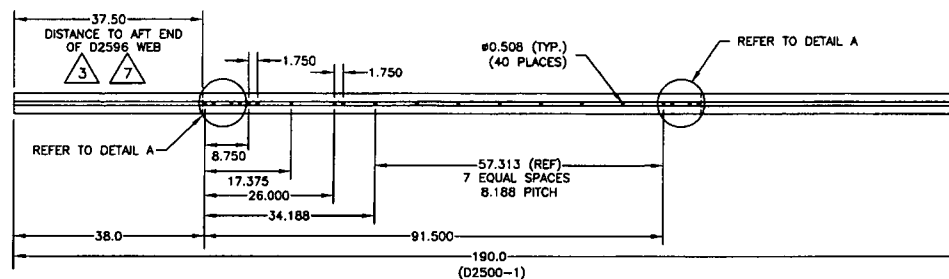
**DETAIL A**  
SCALE 5:24



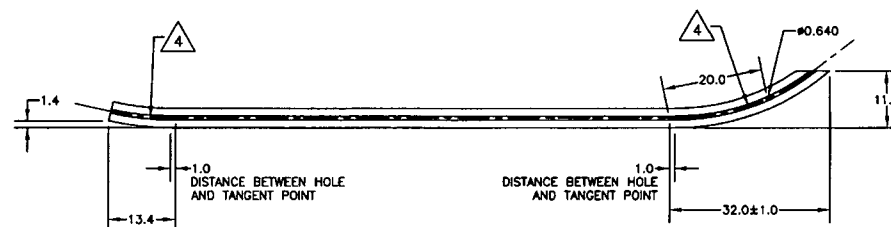
**DETAIL B**  
SCALE 5:24



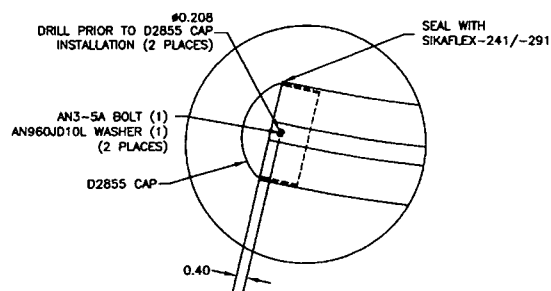
**D2580-1 DRILLING DETAIL**



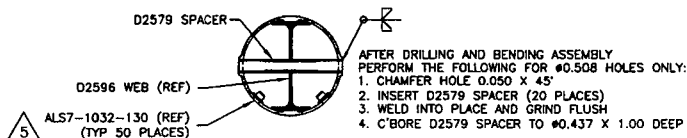
**D2580-1 BENDING AND CUTTING DETAIL**



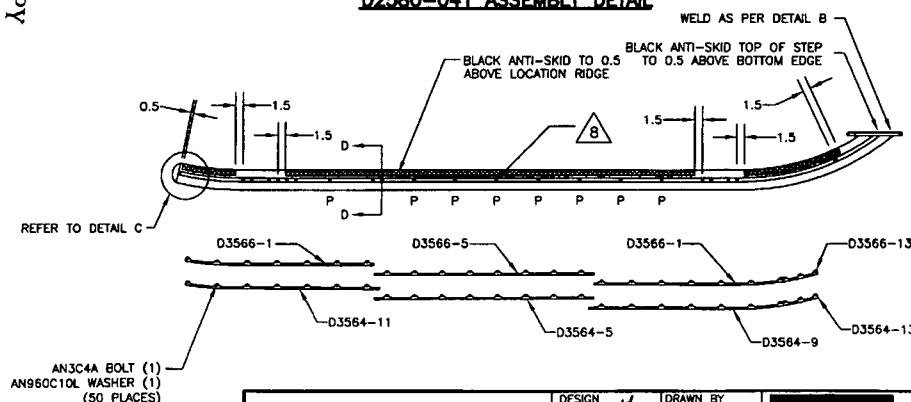
**DETAIL C**  
SCALE 5:24



**SECTION D-D**  
SCALE 5:24



**D2580-041 ASSEMBLY DETAIL**



**D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD. MARKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. 0
DATE	07.02.27	D2580	SHEET 2 OF 3
		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

RELEASED  
07-16-28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of a component with a central hole. The grinding locations are indicated by arrows and labels: GRIND FLUSH (4 PLACES), GRIND FLUSH, D2576-3 STEP, GRIND FLUSH, and LOCATION RIDGE ON UNDERSIDE OF D2576.

DRILL PRIOR TO D2855 CAP  
INSTALLATION (2 PLACES)

SEAL WITH  
SIKAFLEX-241/-291

AN3-5A BOLT (1)  
960JD10L WASHER (1)  
(2 PLACES)

D2855 CAP

SEE NOTE ii)

0.40

D2579 SPACER

D2596 WEB (REF)

AL57-1032-130 (REF)  
(TYP. 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY,  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 x 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO #0.437 x 1.00 DEEP

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WITHOUT NOTICE  
WORK ORDER  
NO. 510273

[illegible]

(MAKE FROM D2580-1 DRILLING DETAIL)

5.985

5.338 (REF)

51.340

39.580

5.915

3.630 (REF)

0.508 (8 PLACES)

20.0

0.640

1.4

1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT

13.4

32.0 ± 1.0

11

**D3560-049 ASSEMBLY DETAIL**

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

REFER TO DETAIL G

H

P P P P P P P P

B

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)


(50 PLACES)

DESIGN	DRAWN BY
--------	----------

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE  
WITH THE SPACER AT THIS LOCATION

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PH
CHECKED 
DATE 07.02.27

APPROVED *[Signature]*

DRAWING NO.	REV. D
02580	SHEET 3 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

NO. 207

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 50849  
Part number: D205-624-041  
Description: 205 skt tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pct. Dwyer Date of Test Coupon 09.08.27

Welder Barclay Elliott Date of Test Coupon 09.08.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld